

Work Order ID 66228

February 8, 2011 8:43:03 AM



PRELIMINARY ISSUE

Page 1

Item ID: D4154-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate Assembly

Start Date: 2/08/11 Start Qty: 4.00



Cust Item ID:

Required Date: 2/22/11 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CZ

Date: 11/02/08 Tooling:

Date:

Stop



QC:

Date: SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4154

100



Large Fab

Large Fab

Memo

1- on D4155-1, fill cut outs with hardcoat welding rod as per dwg D4154

2059 B Hardcoat Welding Rod

BATCH # 1117189

2-weld D4155-1 to wearplate by positioning holes together as per dwg D4154

304 S.S. Welding Rod

BATCH # 1107057

3-Transfer drill holes in bar

4- Use DT9684 to check fit after welding

110

QC9- Inspect visual per QS1004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

E 1-4-11 (X2)

Pl 11.04.11

Work Order ID 66228

February 8, 2011 8:43:03 AM



Page 2

Item ID: D4154-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate Assembly

Start Date: 2/08/11 Start Qty: 4.00



Cust Item ID:

Required Date: 2/22/11 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

120

QC'S- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

m 11. 04. 11 (2)

130

Grey Sandtex(Ref 4 3.5 6) per QSI005-1.1

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME: 10:05
OVEN TEMPERATURE: 320°
FINISH TIME: 10:35

2 11-4-11.

140

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

11/04/11 (2)

Work Order ID 66228

February 8, 2011 8:43:03 AM



Page 3

Item ID: D4154-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Weaplate Assembly

Start Date: 2/08/11 Start Qty: 4.00



Cust Item ID:

Required Date: 2/22/11 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

0.00



Small Fab

Memo

0.00

Small Fab

1- After finish, coat entire top (concave) surface as per note 11 on sheet 2 of 3
dvg D4154

Rockguard Black

4715

4116210

11/04/11

160

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

ml 11 04 11 (2)

170

0.00



Packaging

Identify as per dvg & Stock Location: FP-9

Memo

0.00

Packaging

2 d 11/04/11

Work Order ID 66228

February 8, 2011 8:43:03 AM



Page 4

Item ID: D4154-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate Assembly

Start Date: 2/08/11 Start Qty: 4.00



Cust Item ID:

Required Date: 2/22/11 Req'd Qty: 4.00



Customer:

Reference:

Run Start

Picklist Print

February 8, 2011 8:43:03 AM

Page 1

Work Order ID: 66228

Parent Item: D4154-041

Parent Item Name: Wearplate Assembly



Start Date: 2/08/11

Required Date: 2/22/11

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.09.21 new issue DD ver:EC
10.11.04 added DT9684 DD ver:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4154-1

Manufactured No

100

Each

6.0000

1

4



Plate



EL 1-4-11

Location

Loc Qty

Loc Code

B66173 ~~2~~ x2

WA

6

65079

6

D4155-1

Manufactured No

100

Each

11.0000

1

4



Bar



EL 11-4-11

Location

Loc Qty

Loc Code

ST

2

60976

2

WA

9

62709

1

65080

8

B66174 ~~2~~ x1

B65080 x1

ITEM	QTY	P/N	DESCRIPTION
	X	D4154-041	WEARPLATE ASSEMBLY
1	1	D4154-1	PLATE
2	1	D4155-1	BAR
3	N/R	2058H	HARDCOAT
4	N/R	PR 1422	SEALANT (SEE NOTE 11, SHT 2)

ALL DIMENSIONS
 UNLESS OTHERWISE
 SPECIFIED ARE IN
 INCHES TO TWO DECIMAL
 PLACES. FRACTIONS
 SHALL BE IN
 16ths OF AN INCH.
 10/6/22
 11/10/2108

D4154-041 WEARPLATE ASSEMBLY

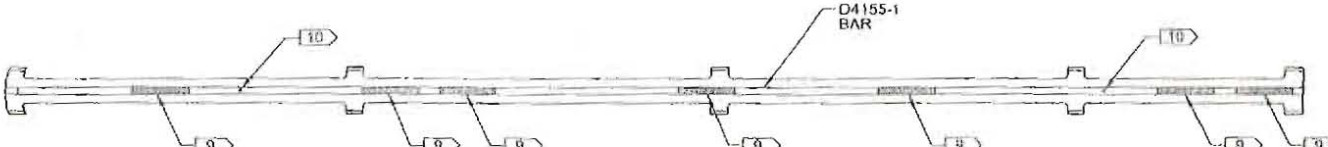
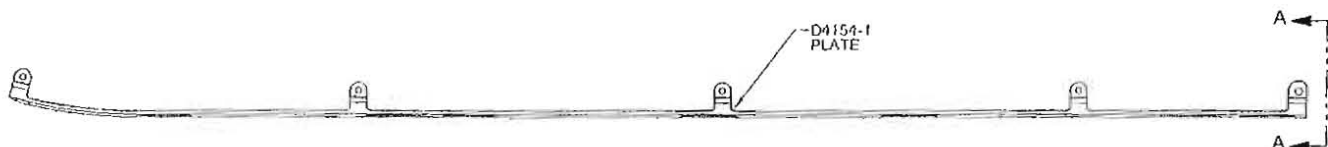
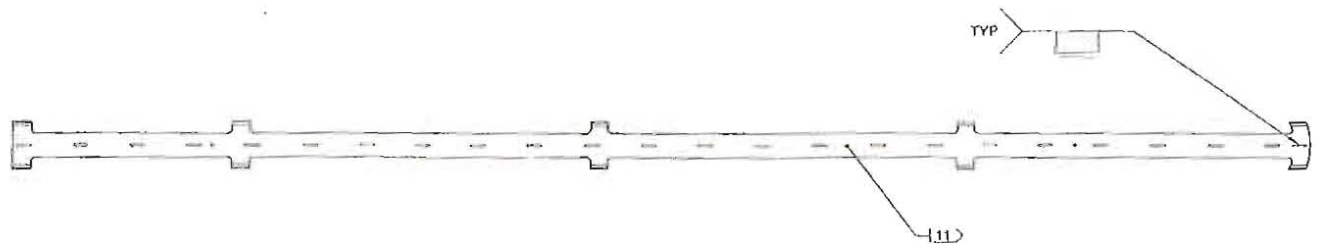
REV	DESCRIPTION	BY	DATE
A	NEW ISSUE	SC	10.07.22
DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	SC	DRAWING NO. D4154	
CHECKED		REV. A	
MFG. APPR.		SHEET 1 OF 3	
APPROVED		SCALE	
DE APPR.		N/A	
DATE	10.07.22	WEARPLATE ASSEMBLY	

RELEASED
 2010-09-15

COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.
 ALL RIGHTS RESERVED. NO PART OF THIS DOCUMENT MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE USA, INC.

RELEASED
2010-09-15

A	NEW ISSUE	SC	10.07.22
REV		DESCRIPTION	BY DATE
DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA DRAWING NO. D4154 TITLE WEARPLATE ASSEMBLY <small> COPYRIGHT © 2016 BY DART AEROSPACE USA, INC. NO REPRODUCTION OR TRANSMISSION IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE USA, INC. </small>	REV. A
DRAWN	SC		SHEET 1 OF 3
CHECKED			SCALE
MFG APPR			NIS
APPROVED			
DE APPR.			
DATE	10.07.22		



D4154-041 WEARPLATE ASSEMBLY

UNCONTROLLED
SUBJECT TO APPROVAL
WITHOUT NOTICE
REF: 66228

RELEASED
2010-09-15



SECTION A-A

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D4154-041" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 5.99 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D4154-1 BAR ON ALL 3 SURFACES AT 7 PLACES
- 10) TRANSFER DRILL Ø0.188 HOLES FROM D4154-1 PLATE TO D4155-1 BAR
- 11) AFTER FINISH, COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF SIKAFLEX-2411-291 OR PROSEAL 890 OR PROSEAL 1422 OR MIL-S-8802 CLASS B SEALANT, 0.020-0.040 THICK.

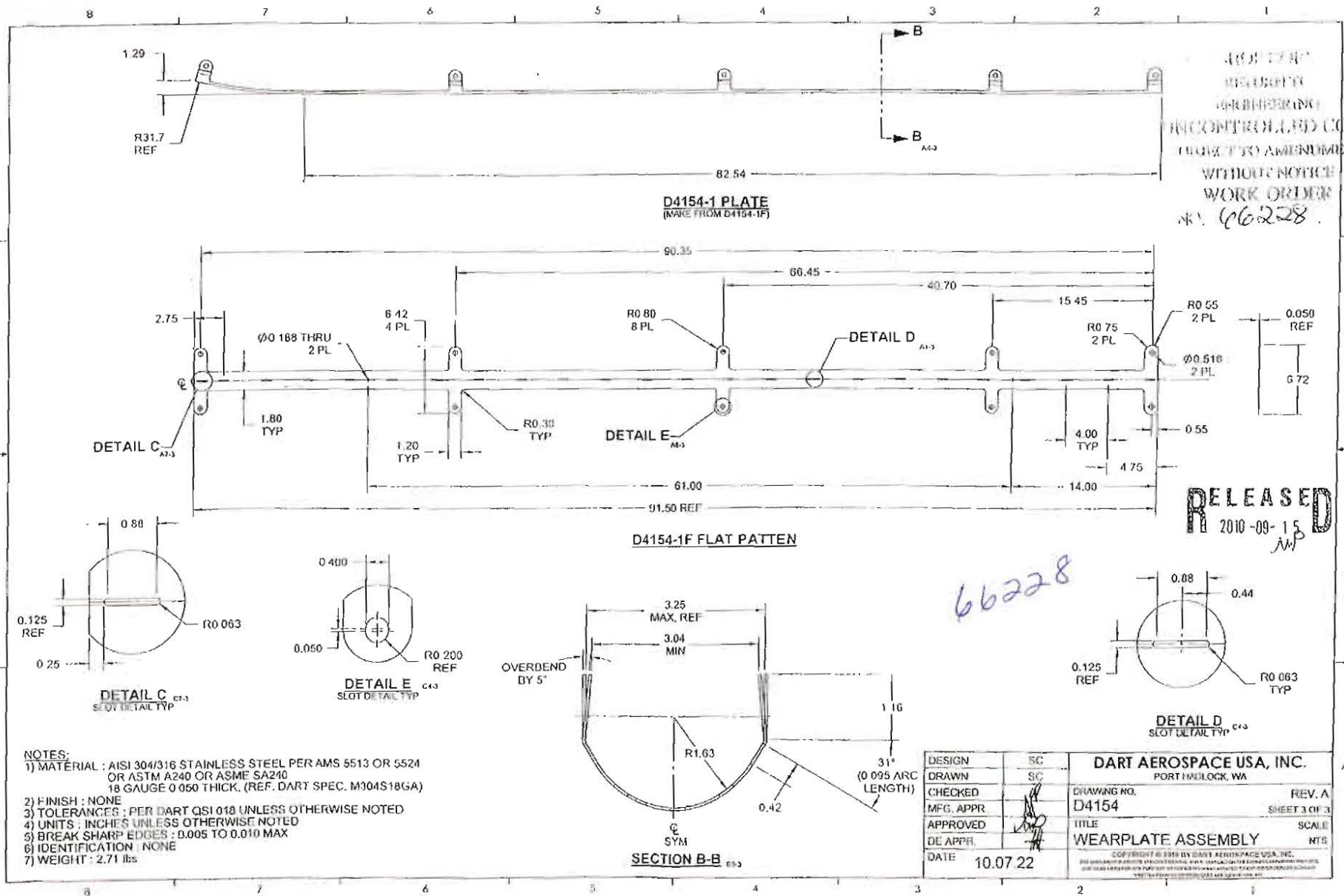
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	SC	DRAWING NO.	REV. A
MFG. APPR.	SC	D4154	SHEET 2 OF 3
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	WEARPLATE ASSEMBLY	NIS
DATE	10.07.22	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.	

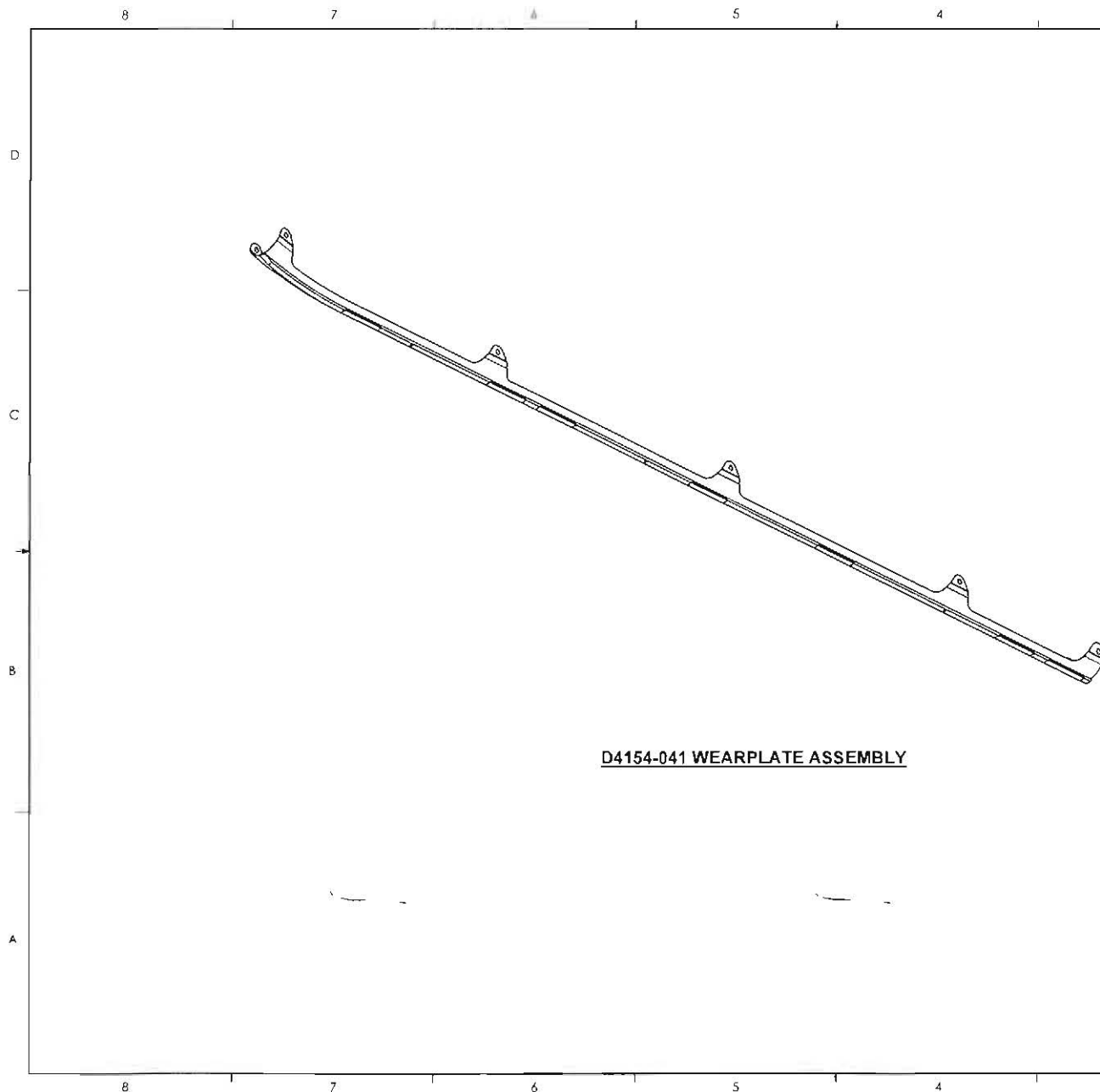
Rock guard Black 4715 MP 11/04/01

UNCONTROLLED COPY
 FOR THE AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 66228

RELEASED
 2010-09-15

66228





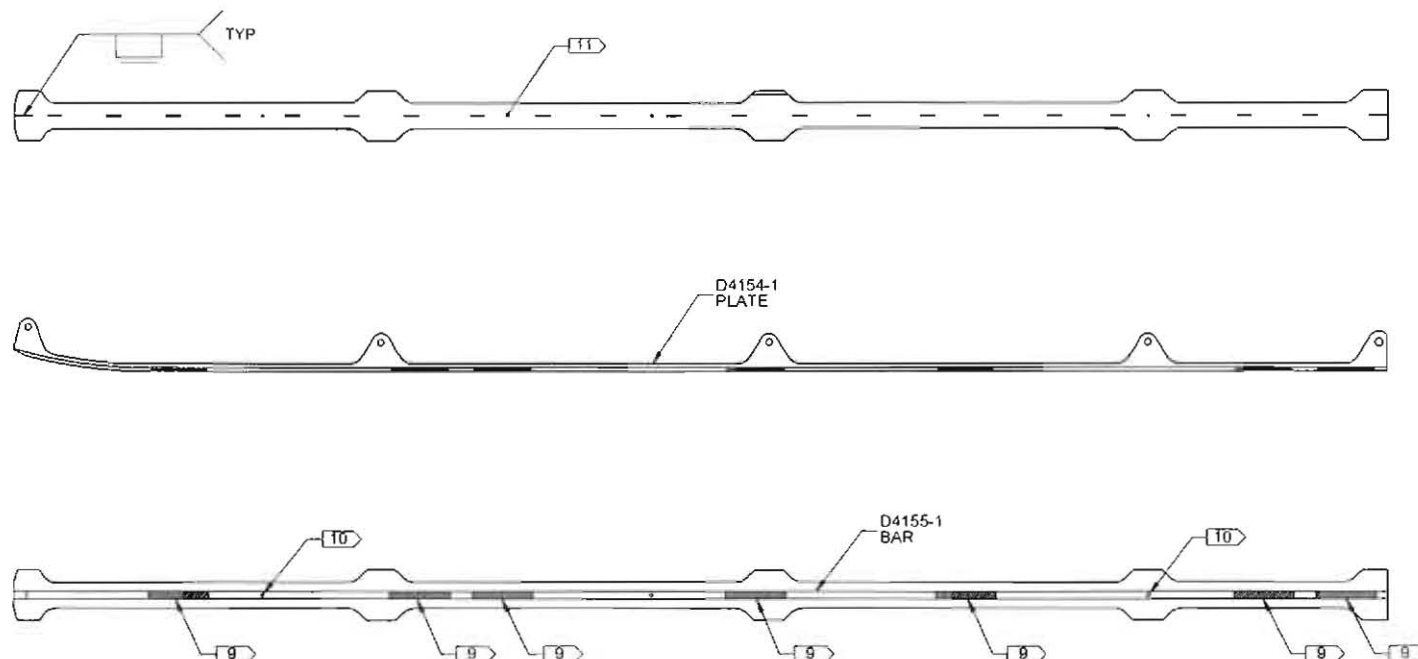
ITEM	QTY	P/N	DESCRIPTION
	X	D4154-041	WEARPLATE ASSEMBLY
1	1	D4154-1	PLATE
2	1	D4155-1	BAR
3	A/R	2059B	HARDCOAT
4	A/R	4714	PLUS ONE ROCKGUARD (SEE NOTE 11, SHT 2)

PB1

PRELIMINARY ISSUE

11.04.05

PB1	ITEM 4 WAS PR1422 (D3-1) REMOVED FINISH TO NOTE 2 (A8-2). REMOVED SECTION A-A (NO LONGER REQUIRED); REVISED D4154-1F		MB	11.04.05
A	NEW ISSUE		SC	10.07.22
REV.	DESCRIPTION		BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC.		
DRAWN		PORT HADLOCK, WA		
CHECKED		DRAWING NO.	REV. PB1	
MFG. APPR.		D4154	SHEET 1 OF 3	
APPROVED		TITLE	SCALE	
DE APPR.		WEARPLATE ASSEMBLY		NTS
DATE	11.04.05	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE. IT IS THE PROPERTY OF DART AEROSPACE USA, INC. AND IS LOANED TO YOUR ORGANIZATION. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.</small>		



D4154-041 WEARPLATE ASSEMBLY

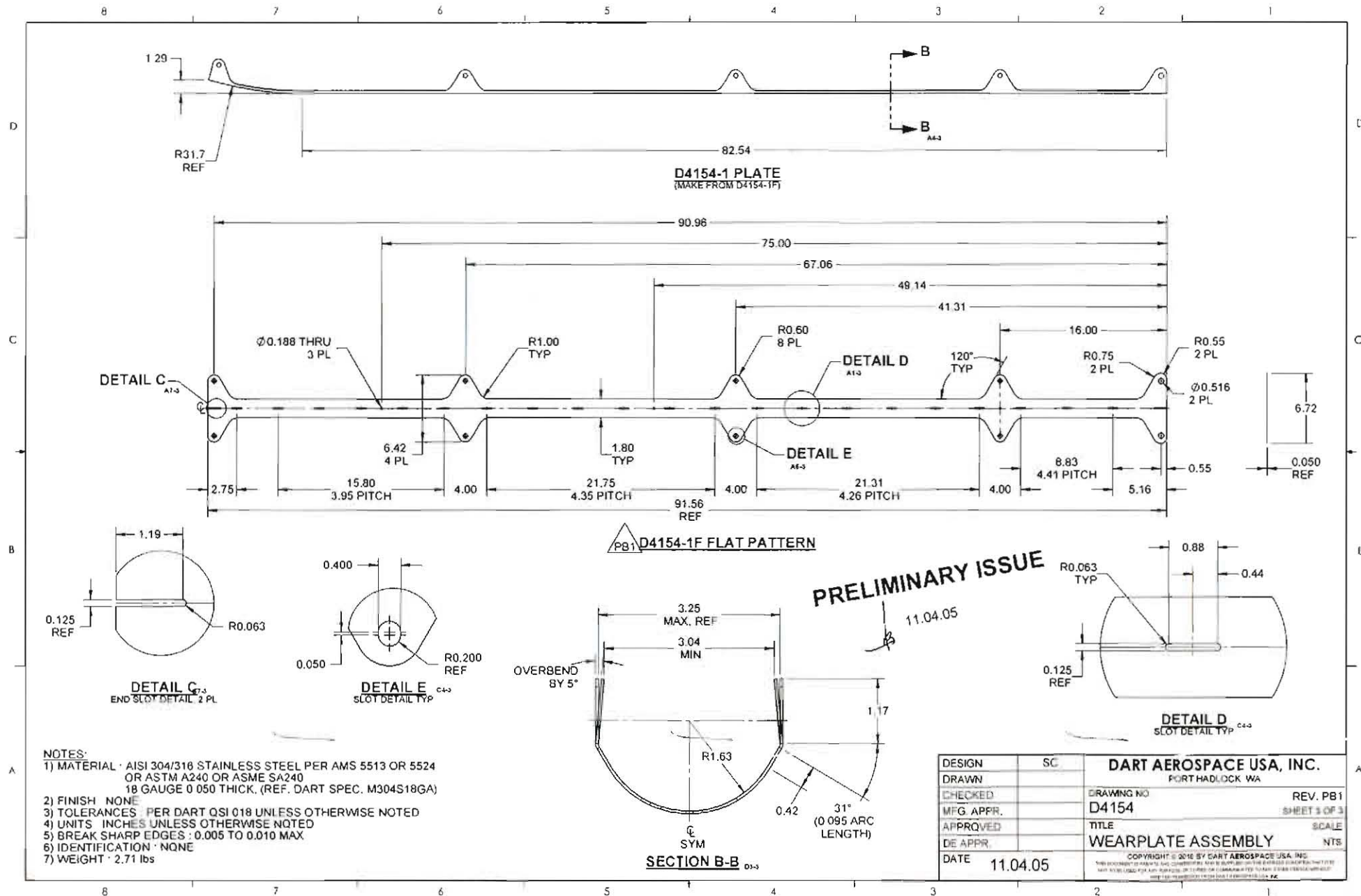
NOTES

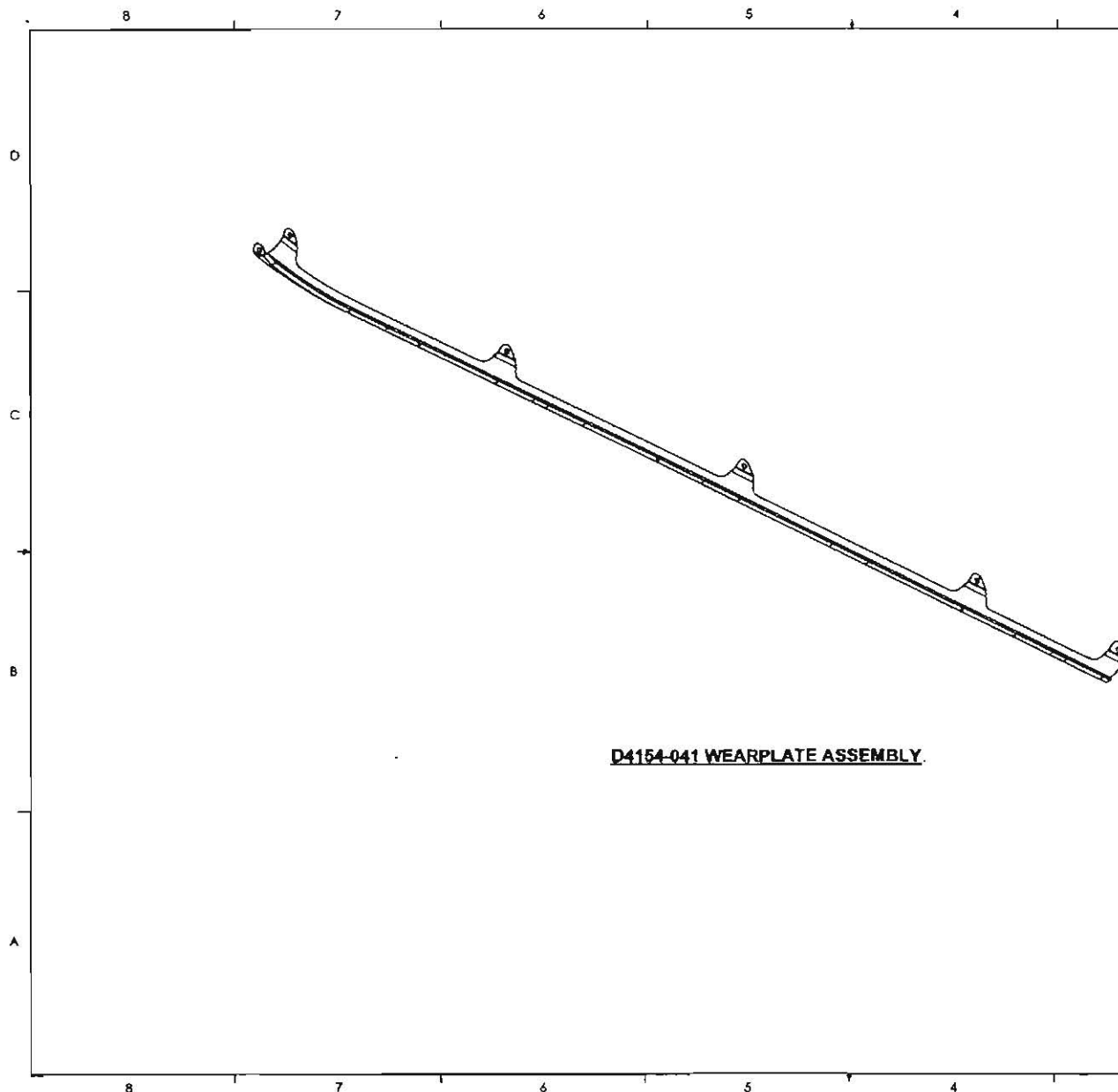
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D4154-041" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 5.99 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.13 THICK X 0.50 WIDE, FLUSH WITH D4154-1 BAR ON ALL 3 SURFACES AT 7 PLACES
- 10) TRANSFER DRILL Ø0.188 HOLES FROM D4154-1 PLATE TO D4155-1 BAR
- 11) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF SIKAFLEX-241/-291 OR PROSEAL 890 OR PROSEAL 1422 OR MIL-S-8802 CLASS B SEALANT, OR PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK

PRELIMINARY ISSUE

11.04.05

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. PB1
MFG. APPR.		D4154	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR		WEARPLATE ASSEMBLY	NTS
DATE	11.04.05	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.	





D4154-041 WEARPLATE ASSEMBLY.

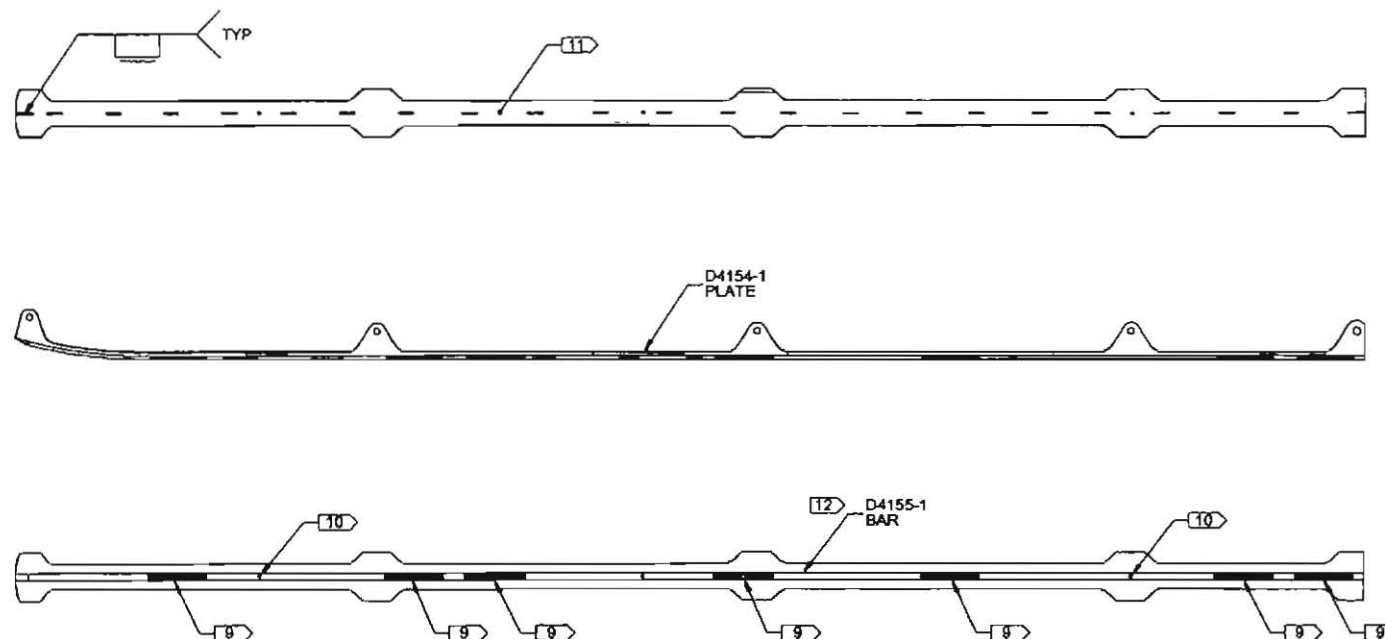
ITEM	QTY	P/N	DESCRIPTION
	X	D4154-041	WEARPLATE ASSEMBLY
1	1	D4154-1	PLATE
2	1	D4155-1	BAR
3	A/R	2059B	HARDCOAT
4	A/R	4714	PLUS ONE ROCKGUARD (SEE NOTE 11, SHT 2)

△ B

66228

RELEASED
2011-04-12
JMP

B	ITEM 4 WAS PR1422 (03-1); REMOVED FINISH TO NOTE 2 (AS-2); REMOVED SECTION A-A (NO LONGER REQUIRED); REVISED D4154-1E	MB	11.04.05
A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	SE	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	SE	DRAWING NO.	REV. B
CHECKED	11/4	D4154	SHEET 1 OF 3
MFG. APPR.	11/4	TITLE	SCALE
APPROVED	11/4	WEARPLATE ASSEMBLY	
DE APPR.	11/4	NTS	
DATE	11.04.05	<small>COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. ALL RIGHTS RESERVED. NO PART OF THIS DOCUMENT MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE USA, INC.</small>	



D4154-041 WEARPLATE ASSEMBLY

RELEASED
2011-04-13

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D4154-041" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 6.88 lbs
- 8) WELDING: PER QSI 004
- 9) 2050B HARD COAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D4154-1 BAR ON ALL 3 SURFACES AT 7 PLACES
- 10) TRANSFER DRILL $\varnothing 0.188$ HOLES FROM D4154-1 PLATE TO D4155-1 BAR
- 11) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 12) FORM TO MATCH PROFILE OF D4154-1 AT TIME OF WELDING

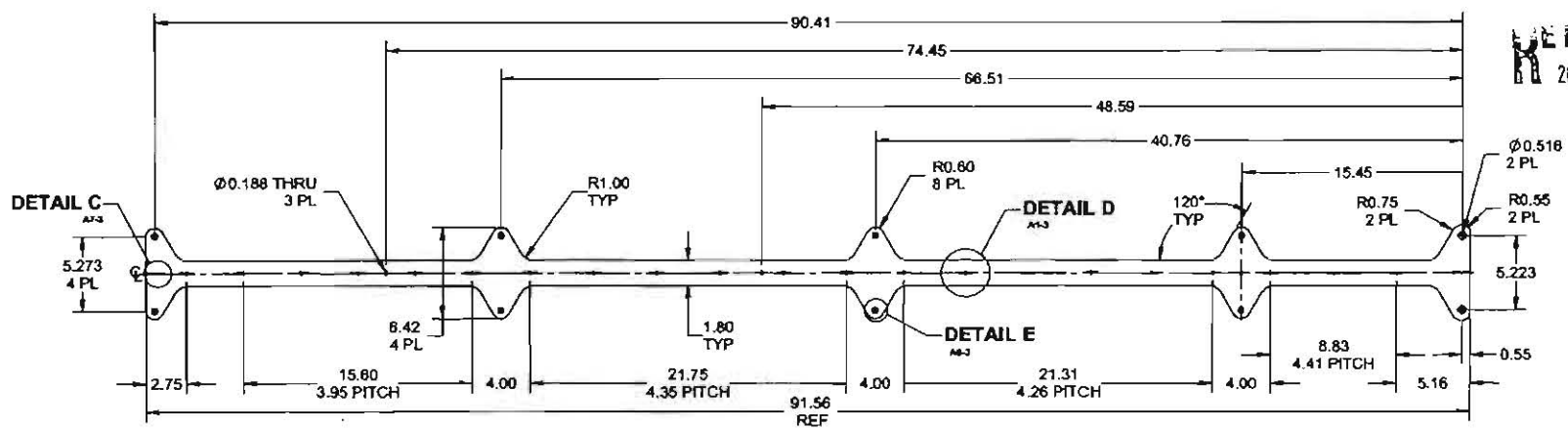
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	SC	DRAWING NO. D4154	REV. B
MFG. APPR.	SC	SHEET 2 OF 3	
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	WEARPLATE ASSEMBLY	NTS
DATE	11.04.05	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC.	



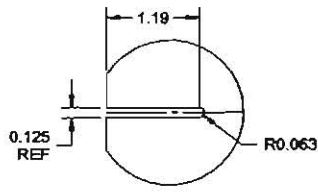
D4154-1 PLATE
(MAKE FROM D4154-1F)

66228

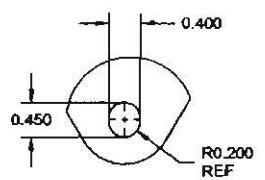
RELEASED
2011-04-13



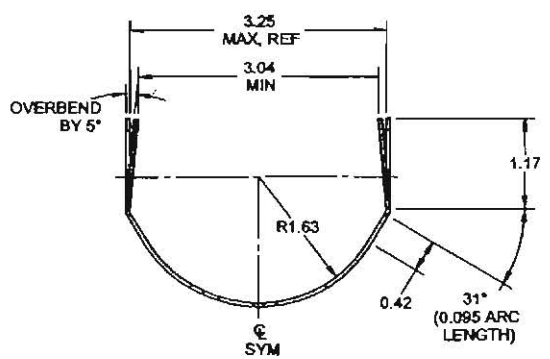
D4154-1F FLAT PATTERN



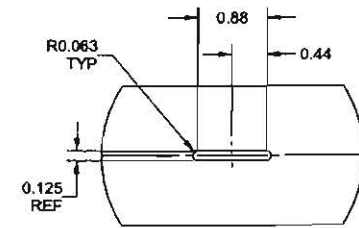
DETAIL C
END SLOT DETAIL, 2 PL



DETAIL E
SLOT DETAIL TYP



SECTION B-B



DETAIL D
SLOT DETAIL TYP

- NOTES:**
- 1) MATERIAL : AISI 304/316 STAINLESS STEEL PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
 - 2) FINISH : NONE
 - 3) TOLERANCES : PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS : INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES : 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION : NONE
 - 7) WEIGHT : 2.95 lbs

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4154	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSEMBLY	NTS
DATE	11.04.05	COPYRIGHT © 2015 BY DART AEROSPACE USA, INC.	